

Work Order ID 139054

Friday, November 13, 2015 11:21:49 AM

139054

Page 1

Item ID: D5076-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Inboard Bracket Assembly
 Start Date: 11/13/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: NOV 17 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5076	A								

110 0.00
110
 Packaging Memo 0.00 2 FF DEC 23 2015
 Packaging

120 0.00
120
 Small Fab Memo 0.02 2 FF DEC 23 2015
 Small Fab 1-Assemble as per dwg, do not install grommets and rubber seal.

130 0.00
130
 QC Memo 0.00 (2)
 Quality Control

DAS
38
9-89

IAN 04 2016

DQA:

Date:

16/02/04

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only

Work Order: <u>139054</u> Part No: <u>5076-1</u> NCR No: <u>D4434-9</u>		DISPOSITION Rework ☒ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Date: <u>15.12.22</u>		Step #: <u>120</u>		QTY Effective: <u>2</u>		MRB (QSI042) Approval D.A.S. 15 <u>15/12/22</u>																																																																									
Description Work Order Deviation				Disposition		Completed By <u>FF</u> JAN 04 2016																																																																									
installing D4434-9 onto D5076-1 ON inside in place of outside 2 holes were drilled that not line up when placing D4434-9 on outside of D5076-1 RC Not to work over Do not specify how to correctly manufacture / assemble the part .				SCRAP + DESTROY to Replace FF correct work instruction to have more detail on how to correctly manufacture / assemble		Lead hand / Supervisor Approval Verification 38 9-89 ... 04 2016																																																																									
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140 *140* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>m 129777</i> Memo *** MASK NUT PLATE HOLES PER DWG *** START TIME: <i>2:45</i> OVEN TEMPERATURE: <i>350</i> FINISH TIME: <i>3:15</i>	0.00 0.00				<i>2</i>	<i>0</i>	<i>16-01-5</i>	<i>2 3 00</i>
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>2</i>	<i>FF</i>	<i>JAN 0 5 2016</i>	
160 *160* Small Fab Small Fab	Memo Install rubber seals and grommets. 3M 1300 batch: <i>7132830</i>	0.00 0.02				<i>2</i>	<i>FF</i>	<i>JAN 0 6 2016</i>	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

DAS
38
9-89
JAN 06 2016

180

Identify as per dwg & Stock Location 8624

0.00

180

Packaging

Memo

0.00

Packaging

2 DAS
8
9-89
JAN 11 2016

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ JAN 11 2016

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								QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☒ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____		

Friday, November 13, 2015 11:21:48 AM

139054

D5076-043

Required Date: 11/13/2015

Required Qty: 2.00

Comments: IPP REV:A 14.04.01 PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-9		Manufactured	No			110	Each	0.0000	1	2			
D4434-9					B 1396.6				**	2	FF	DEC 22 2015	
Bracket													
D4441-1		Manufactured	No				f	500.3694		1.066			
D4441-1									**		FF	JAN 06 2016	
Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				355.875					
					120932			355.875					
				ST422				144.4944					
					120932			144.4944		1.066			
D4441-1		Manufactured	No				f	500.3694		1.1			
D4441-1									**		FF	JAN 06 2016	
Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				355.875					
					120932			355.875					
				ST422				144.4944					
					120932			144.4944		0.866 1.1			
D4441-1		Manufactured	No				f	500.3694		0.866			
D4441-1									**		FF	JAN 06 2016	
Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				355.875					
					120932			355.875					
				ST422				144.4944					
					120932			144.4944		0.866			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

Picklist Print

Friday, November 13, 2015 11:21:48 AM

Page 2

Work Order ID: 139054

139054

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 2.00

Required Qty: 2.00

D4441-1

Manufactured No

f

500.3694

1.56

D4441-1

Rubber Seal

**

FF

JAN 06 2016

Location

Loc Qty

Loc Code

ST407

355.875

120932

355.875

ST422

144.4944

120932

144.4944

D5076-1

Manufactured No

110

Each

3.0000

1

2

D5076-1

Bracket

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST245

3

130526

3

D5076-3

Manufactured No

110

Each

4.0000

1

2

D5076-3

Bracket

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST248

4

130527

4

D4435-041

Manufactured No

110

Each

7.0000

1

2

D4435-041

Bracket Assembly

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST098

7

136417

1

137113

6

DEC 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition		Completed By																
					Lead hand / Supervisor Approval Verification																
					QC / QA Coordinator Approval																
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Picklist Print

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Page 3

Work Order ID: 139054

139054

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 2.00

Required Qty: 2.00

D4441-1 Manufactured No

D4441-1

Rubber Seal

500.3694

0.284

FF JAN 06 2016

Location

Loc Qty

Loc Code

ST407

355.875

120932

355.875

ST422

144.4944

120932

144.4944

0.284

0.416

FF JAN 06 2016

D4441-1 Manufactured No

D4441-1

Rubber Seal

500.3694

Location

Loc Qty

Loc Code

ST407

355.875

120932

355.875

ST422

144.4944

120932

144.4944

0.416

2

FF DEC 22 2015

D4440-1 Manufactured No

D4440-1

Grommet

160

Each

21.0000

1

Location

Loc Qty

Loc Code

GA

21

129462

1

134762

20

110

Each

88.0000

3

6

FF JAN 06 2016

AN525-832R6

Purchased No

AN525-832R6

Screw

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST328

74

m131957

74

5X

6

Friday, November 13, 2015 11:21:48 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐																		

Picklist Print

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Page 4

Work Order ID: 139054

Parent Item: D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

139054

D5076-043

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-3

Purchased

No

110

Each

4,700.000

14

28

MS20426AD3-3

RIVET

**

DEC 22 2015

Location

Loc Qty

Loc Code

GA

1918

M131624

1918

ST312

2782

M131624

2782

MS20470AD4-3

Purchased

No

110

Each

1,412.000

15

30

MS20470AD4-3

Rivet - Universal Head

**

DEC 22 2015

Location

Loc Qty

Loc Code

GA

845

2193

845

ST310

567

2193

567

MS21075L08

Purchased

No

110

Each

232.0000

7

14

MS21075L08

ANCHOR NUT

**

DEC 22 2015
6
9-89

Location

Loc Qty

Loc Code

ST298

123

103053

55

M132035

68

ST300

109

M128635

109

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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OTHER : _____					